



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10-4-8
Job Sheet 175891



Part No: C10-4-8

Job Qty: 20 pcs

Part Name: Lock Bushing



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-4-8 Rev 1A IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/19/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	20 pcs		4/20/18	0.00	1.33	MORI SL-154		
120	QC	20 pcs		4/20/18	0.00	0.00	QC2 Machining-4		
130	QC	20 pcs		4/20/18	0.00	0.00	QC8 Machining-4		
135	Outsource	20 pcs		4/20/18			ATL002-VC ATLANTIC		
140	Outsource	20 pcs		4/20/18			GRO002-VC 10		
150	Packaging	20 pcs		4/20/18	0.00	0.00	Packaging2		
160	QC	20 pcs		4/20/18	0.00	0.00	QC6		

Part Op 110 - 1-Machine as per folio FC021 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: 135 - 1--Issue P/O to ATLANTIC HEAT TREAT 2001 ; P/O 00055 RC 37-40 2-Bead blast 3- Certificate of Conformity is required

140 - 1--Issue P/O to Groupe Altech: P/O 040148 -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R1.000	4140 round bar 1.00	1.3800 ft (.069 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4140H-R1.000	1	16	0

Part Specifications

not be found.

Plex 5/22/18 9:08 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S074860



Part: C10-4-8

Job No: 175891

Serial No/Batch: S074860

Revision: 1A

Inspector:

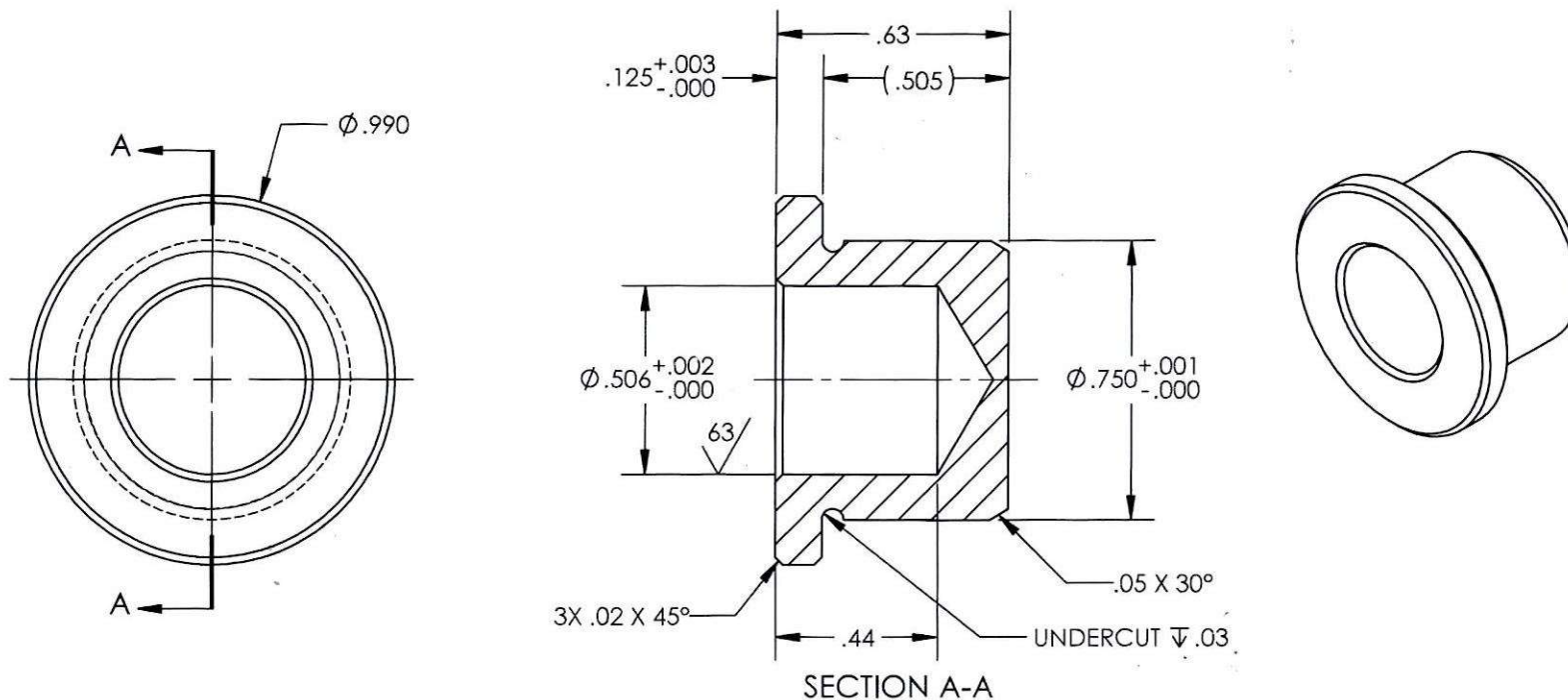
Date: 05/26/18

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM.	4/30/2013	CFS	
1A	14-0115	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/8/2014	DPD	RW



NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK BUSHING	
DWG NO. C10-4-8	REV 1A
MAT'L 4140	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 .XX ± .01 .X ± .1	HEAT TREAT HRC 37-40
FRACTIONS ± 1/8 ANGLES ± 5°	FINISH SEE NOTE 1
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 2:1	DATE 4/26/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C10-4-8	1	LOCK BUSHING	4140	Ø1-1/8 X 3/4

Atlantic Heat Treating (2001) Ltd

Order No.: 155518

Certification

Date: 06/05/2018

Entry Date: 06/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po040035

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
21	21 pcs material 4140 annealing and heated to 37-40 rc sand blast c of c prt# c10-4-8 job # 175891	1

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE

37.

40.

37.5 TESTED AS PER SAMPLING PLAN

HARDEN TO 37.5 RC AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL, (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OR CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformation, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040035**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO040035
PO Date: 5/29/18
Due Date: 6/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172772	C45-4-4K	C45 Load Beam Keeperless 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required MAT'L 4140	Firmed	6/9/18	8 pcs	0 pcs ✓ 8x	8 pcs	\$10.64125/pcs AT 18/06/11	\$85.13
2	174417	C45-4-4	Load Beam 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required MAT'L 4140	Firmed	6/9/18	12 pcs	0 pcs ✓ 12x	12 pcs	\$9.8258333/pcs AT 18/06/11	\$117.91
3	173601	C3-4-4K	Load Beam 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required	Firmed	6/9/18	18 pcs	0 pcs ✓ 18x	18 pcs	\$5.1433/pcs AT 18/06/11	\$92.58

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	175892	C10-9-4	Latch Shaft Bearing 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 37-40 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** MAT'L 4140	Firmed	6/9/18	22 pcs	0 pcs	22 pcs	\$3.40909091/pcs	\$75.00
5	175891	C10-4-8	Lock Bushing 1--Issue P/O to ATLANTIC HEAT TREAT 2001 ; P/O _____ RC 37-40 2-Bead blast 3- Certificate of Conformity is required MAT'L 4140	Firmed	6/9/18	21 pcs	0 pcs	21 pcs	\$3.57142857/pcs	\$75.00
6	172188	C45-4-4K	C45 Load Beam Keeperless 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required	Firmed	6/9/18	8 pcs	0 pcs	8 pcs	\$10.8275/pcs	\$86.62
7	172771	C45-4-4	Load Beam 1--Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required	Firmed	6/9/18	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
Grand Total:										\$607.24
Order Notes										
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 6/7/18 1:40 PM dart.tsimiklis.chrisoula

CT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040148**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040148
PO Date: 6/8/18
Due Date: 6/15/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172772	C45-4-4K	C45 Load Beam Keeperless 1--Issue P/O to Groupe Altech; P/O _____ 2-Nickel Plate .0009 - .00011, bake after plating. Electroless or electroplated is fine 3- Certificate of Conformity is required	Firmed	6/15/18	8 pcs	0 pcs	8 pcs	\$21.25/pcs	\$170.00
	172188			Firmed	6/15/18	8 pcs	0 pcs	8 pcs	\$21.25/pcs	\$170.00
Sub Total:						16	0	16		\$340.00

2	174417	C45-4-4	Load Beam 1--Issue P/O to Groupe Altech; P/O _____ 2-Nickel Plate .0009 - .00011, bake after plating. ELeetroless or electroplated is fine. 3- Certificate of Conformity is required	Firmed	6/15/18	12 pcs	0 pcs	12 pcs	\$21.25/pcs	\$255.00
	172771			Firmed	6/15/18	3 pcs	0 pcs	3 pcs	\$21.25/pcs	\$63.75
Sub Total:						15	0	15		\$318.75

3	173601	C3-4-4K	Load Beam -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009- .0011 - Certificate of Conformity is required	Firmed	6/15/18	18 pcs	0 pcs	18 pcs	\$13.25/pcs	\$238.50
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6/13/2018

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	175891	C10-4-8	Lock Bushing 1--Issue P/O to Groupe Altech; P/O _____ 2. Nickel Plate .0004 - .0006, bake after plating. ELectroless or electroplated is fine. 3- Certificate of Conformity is required 1--Issue P/O to ATLANTIC HEAT TREAT 2001 ; P/O _____ RC 37-40 2-Bead blast 3- Certificate of Conformity is required -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	6/15/18	21 pcs	0 pcs	21 pcs	\$9.00/pcs	\$189.00
									21x	4 mps 180628.
									Grand Total:	\$1,086.25
Order Notes										
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 6/13/18 1:55 PM dart.tsimiklis.chrisoula

CJ.



Certificat de Conformité / Certificate of Compliance

(010207-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010207 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
27-Jun-2018		Aman			040148			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	C10-4-8 Rev.	C10-4-8 NICKEL PLATE 0.0004-0.0006 THICK AND BAKE	E-NICKEL STEEL CH	21	21	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.